

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015619**Date Inspected:** 07-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	Orthotropic Box Girder( OBG)				

**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

Segment # 11DW (Green Tag)

This QA performed a joint survey dimensional inspection of corner assembly cope holes on segment 11DW. The inspection was performed along with Caltrans (CT) QA Mr. Manjunath Math, Measurements of the cope holes were taken from PP104 to PP106.5 at the following locations: E1~E2, S1~S5 and T1~T3 on both the crossbeam and Counter Weight sides. Details of these locations can be found on CT / QA document titled "OBG DCP Hand Measurement Survey: Corner Assembly Cope Holes". This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

Segment # 11DW

This QA performed a joint survey dimensional inspection of segment 11DW. The inspection was performed along

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

with Caltrans (CT) QA Mr. Manjunath Math, following.

OBG DCP Hand Measurement Survey Corner Assembly Side plate to Side plate and Deck Plate to Deck plate flatness from PP 104 ~ PP 106 Cross Beam and Counter Weight side and

OBG DCP Hand Measurement Survey WT Stiffener Vertical offset, Horizontal offset and Buckling from Panel point 104, 105~105.5, 105.5 to 106 FL3 area Cross Beam Side

OBG DCP Hand Measurement survey Deck panel Diaphragm plate plumbness and flatness at panel point 104 to 106 east and west side of the Diaphragm.

The recorded measurements submitted to lead as well to the engineer for further action.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Prabhune,Manoj	Quality Assurance Inspector
----------------------	----------------	-----------------------------

---

<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer
---------------------	------------------	-------------